

Date: Monday, 4/23/2007 3:41:34 PM
 User: Kim Johnston

Process Sheet

Split
SB 07/12/18

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 32016 -1	
Estimate Number : 10267	
P.O. Number : <i>N/A</i>	Part Number : D2438
This Issue : 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2438 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 30631	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/15/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>100</i> Um: Each
Comment : Est: E 05.06.28 Bending removed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *3619*

Laser cut as per Dwg D2438

Material release note is required

CL 07/04/24 *(200)*

LYE laser cut + formed

2.0

D2438B

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)

CLAMP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7/12/14 SD 200

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

SG 07.12.19

100

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

SAJ 07-12-19

100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 21/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entres

Date: Monday, 4/23/2007 3:41:34 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 32016

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



25019



counts

Comment: INSPECT WORK TO CURRENT STEP

4/12/21 (x100)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST460

AS 07/12/21

(x100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(x100)

Comment: FINAL INSPECTION/W/O RELEASE

1707/12/24

Job Completion



u 07.12.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

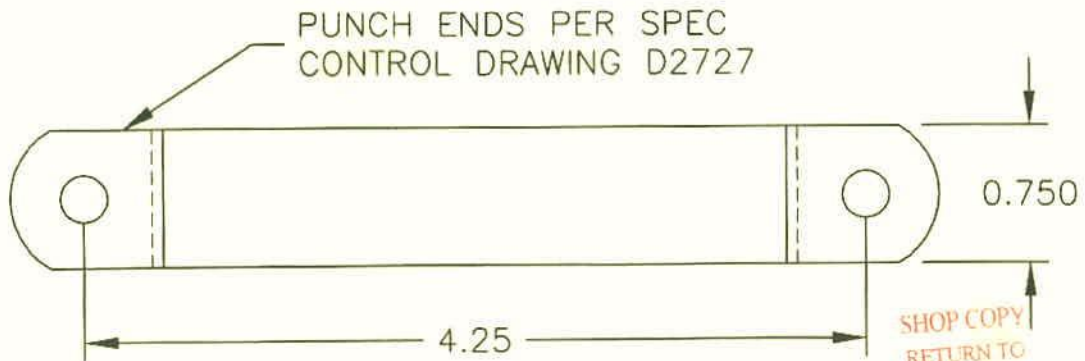
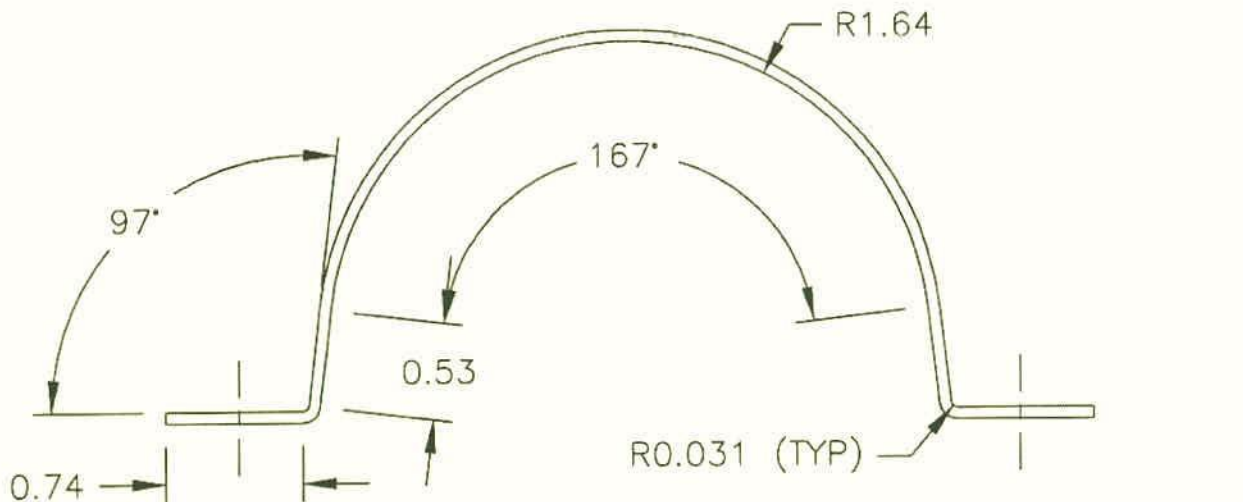
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
48.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32016

00.06.06
CP 00.06.07



CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Member of Thomas & Betts

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9S 1M1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>12</u>	OUR JOB NO.	<u>J0172854</u>	SHIPPING MEMO	<u>0381158</u>
QTY	<u>200 PCS</u>	PURCHASE ORDER	<u>PO00003619</u>	PART NUMBER	<u>D2438B</u>
				REV	<u>C</u>
				NAME	<u>CLAMP</u>
				DWG ISSUE	<u>C</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>S.S.T 304</u>		<u>TW METALS / NORTH AMERICAN</u>		<u>IXL6</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			
10			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 13 DECEMBER 2007

G.F.I. Q.C. REP. *Antony H. H. H.*

10/11/2007 15:27 #655 P.003/003

From: FERGUSON METALS

FERGUSON METALS, INC.

This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:

3475 Symmes Road Hamilton, OH 4501

36 X 120
P.O.: 49175254
Sales #: 01044158
QTY: 51

Site: J04L ANN .050-.084 AMS 5513/5511
Customer: TW METALS INC.
Plant: LXA
Shipped: 05/31/07

Authorized Signatory
[Signature]
Lynda Harper



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 357787 02
Customer: 0018 001
Mail To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Ship To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Date: 5/02/2007 Page: 1

Steel: 304/304L

Finish: 2B

Your Order: 01009705

NAS Order: AN 0366117 02

Corrosion: ASTM A262/02a/1802and-GK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/08b, 480/08b, 666/03, ASME SA240/04-A05, 480/04-A05, SA555/04
Q08766D-A XMGPM, AMS5511H/5513H XMR&FN, MIL4043B, AMS, XCRN6AS&FN

REMARKS:

Mat'l free of Hg contam. No weld repairs. RoHS-Compliant.
EN 10204 3.1 PED 97/23/EC Annex 1, Para. 4.3 Q08763F Cond A
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
021XL6 A	* 021XL6 A	.0520	48.0000	10,350 COIL	992.80	11	1	

CHEMICAL ANALYSIS

Heat	CM	C	CR	CU	MN	MO	B	NI	P	S	SI
1XL6	UB	.022	18.335	.396	1.815	.323	.096	8.616	.030	.010	.160

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i o r	UTS KSI	.2% VS KSI	ELONG 1/2"-2"	Hard RB	Tail Hard
021XL6 A	021XL6	F T	91.80	45.40	46.22	82.00	83.50

REVIEWED BY Q.C.
Date 5/4/07 by *[Signature]*

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

3/02/2007

